

# CIGWELD

AN ESAB BRAND

# WELDSKILL 312

## PRODUCT DATA SHEET



## WELDSKILL ELECTRODE HANDY-PACKS FOR ALL OF YOUR SMALLER PROJECTS



STAINLESS STEEL

MILD STEEL

## WELDSKILL 312:

**WELDSKILL 312** is a highly alloyed stainless steel electrode that is extremely resistant to cracking. 312 has a host of features which make it suitable for the welding of all types of steels.

**WELDSKILL 312** has easy arc starting and excellent stability on low Open Circuit Voltage (O.C.V) welding machines.

**WELDSKILL 312** has a rutile type flux coating gives smooth, stable running in all positions (except vertical down) especially on low current settings.

**WELDSKILL 312** Weld deposit gives excellent resistance to corrosion and oxidation. WELDSKILL 312 is recommended for the repair and maintenance of all steels, particularly those of unknown composition. It is suitable for:

- Joining dissimilar steels, such as stainless steel to carbon steel.
- Repairing die or tool steels.
- Use as a protective overlay against corrosion.
- Use as an intermediate or buffer layer prior to hard surfacing.

## FEATURES:

- Easy-to-Use Rutile Type, High Alloy Electrode
- Outstanding Operator Appeal!
- WELDS ALL Steels!
- Ideal for Repair & Maintenance Jobs
- Easy Arc Starting and Excellent Stability on Low O.C.V. Welding Machines
- Not Recommended for Welding Cast Irons

## CLASSIFICATIONS:

AS/NZS 4854:	B ES312-16
AWS/ASME-SFA A5.4:	E312-16

## SPECIFICATIONS:

Diameter (mm)	Current Range (amps)	
	MIN	MAX
2.5	40	80
3.2	75	110

# TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

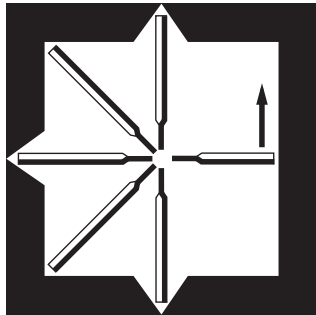
Yield Strength	630 MPa
Tensile Strength	780 MPa
Elongation	25%
CVN Impact Values	30 J av @ +20°C

# TYPICAL ALL WELD METAL ANALYSIS:

C: 0.11%	Mn: 0.60%	Si: 0.88%	Cr: 28.4%
Ni: 9.10%	S: 0.011%	P: 0.020%	

# WELDING POSITIONS:

All positional - except vertical down welding



# ORDERING INFO:

PART NO.	SIZE PACK	SIZE	CARTON
WEW0225	WeldSkill 312 Electrodes 2.5mm	10 rods	20 x 10 rods
WEW1025	WeldSkill 312 Electrodes 2.5mm	1kg	12kg - 12 x 1kg
WEW0232	WeldSkill 312 Electrodes 3.2mm	10 rods	20 x 10 rods
WEW1032	WeldSkill 312 Electrodes 3.2mm	1kg	12kg - 12 x 1kg